

Work Order ID 63214

Monday, October 25, 2010 12:34:56 PM



Page 1

Item ID: D212-725-1-083F

Accept



Setup Start



Revision ID:

Stop



Item Name: Shelf Splice

Start Date: 10/25/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: PL

Date: 10-10-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-725-1	F

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2024 .050

1-Cut as per Dwg

Dwg Rev: F

Prog Rev: F

2-Deburr if necessary

10-10-27

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63214

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Page 2

Item ID: D212-725-1-083F

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Setup Start



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Item Name: Shelf Splice

Stop



Start Date: 10/25/2010 Start Qty: 4.00



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Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
121	Hand Finish								
122	QC 3								
130	Identify as per dwg & Stock Location: 383	0.00							
Packaging	Memo	0.00							
Packaging	***FLAT PATTERN ONLY***								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/10/27

(XL)

H

BR 10-10-28.

Cel/10/28 (4)

10/10/29

PL 10-10-28
(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, October 25, 2010 12:35:01 PM

Page 1

Work Order ID: 63214



Parent Item: D212-725-1-083F



Parent Item Name: Shelf Splice

Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050		Purchased	No			100	sf	106.8847	0.6552	2.758737			
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RB 10-10-07

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

106.8847

111381

11.89

113189

0.3947

114968

94.6

114968

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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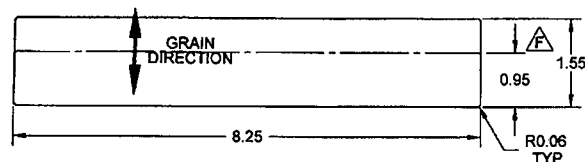
NOTE: Date & initial all entries

DZ12-705-1083K

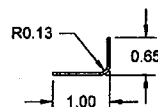
☒ **First Article** ☐ **Prototype**

Measured by:	RB	Audited by:	E	Prototype Approval:	N/A
Date:	10-10-27	Date:	10/10/27	Date:	N/A

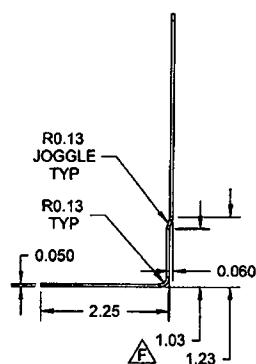
H:\FORMS\Quality Assurance\approved QA\FAI revD



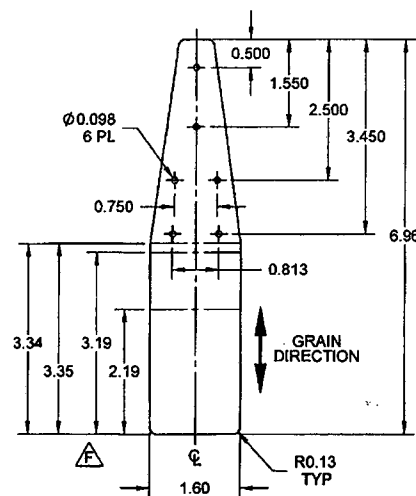
D212-725-1-107F FLAT PATTERN



D212-725-1-107 ANGLE
(MAKE FROM D212-725-1-107F FLAT PATTERN)



D212-725-1-085 BRACKET
(MAKE FROM D212-725-1-085F FLAT PATTERN)



D212-725-1-085F FLAT PATTERN

D212-725-1-085 NOTE:

1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.050)

D212-725-1-107 NOTE:

2) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037
(FER. DART SPEC. M2024T3S.040)

GENERAL NOTES:

- 3) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541, AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

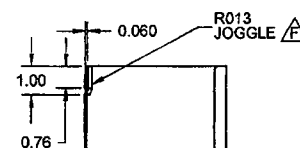
SUBJECT TO AMENDMENT

WITHOUT NOTICE

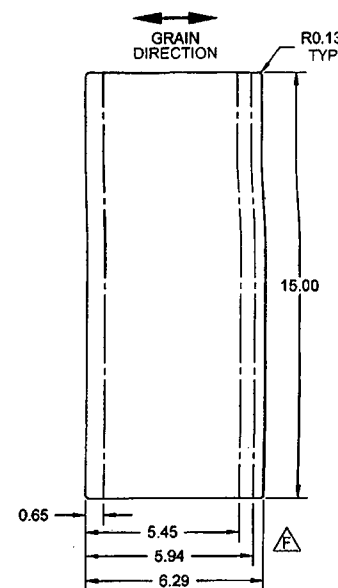
WORK ORDER

NO. 63214

PL10-10-26



D212-725-1-083 SHELF SPLICE
D212-725-1-084 OPPOSITE
(MAKE FROM D212-725-1-083F FLAT PATTERN)






D212-725-1-083F FLAT PATTERN

D212-725-1-083/-084 NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4
(REF. DART SPEC. M2024T3S.050)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

RELEASED
C9/64/67 JWP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 32 OF 84
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.02.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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